

Date: Thursday, 4/12/2007 9:34:26 AM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---|------------------|------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : HINGE BRACKET |
| Job Number | : 31792 | | |
| Estimate Number | : 10349 | | |
| P.O. Number | : <i>N/A</i> | Part Number | : D28582 |
| This Issue | : 4/12/2007 S.O. No.: <i>N/A</i> | Drawing Number | : D2858 REV B |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : <i>NA</i> Type: MACHINED PARTS | Drawing Revision | : B |
| Previous Run | : 29851 | Material | : <i>N/A</i> |
| Written By | : <i>[Signature]</i> | Due Date | : 5/12/2007 Qty: 24 Um: Each |
| Checked & Approved By | : <i>[Signature]</i> | | |
| Comment | : Est C 00.06.22 Removed P/O for powder coat EC | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|--------------|
| Seq. #: | Machine Or Operation: | Description: |
|---------|-----------------------|--------------|

| | | |
|-----|--------------------|--------------------------|
| 1.0 | M6061T6B1500X01250 | 6061-T6 Bar 1.5" x 1.25" |
|-----|--------------------|--------------------------|



Comment: Qty.: 0.1767 f(s)/Unit Total: 4.2412 f(s)
 Material: 1.50" X 1.25"
 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)
 (M6061T6B15001250
 Batch *M101694*

J.L 07/04/16

| | | |
|-----|----------|----------|
| 2.0 | BAND SAW | BAND SAW |
|-----|----------|----------|



Comment: BAND SAW
 Cut blanks 6.02"
 Note: 1 Blank Makes 3 Parts

J.L 07/04/16

| | | |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine per folio D2858-2

J.F / J.L 07/04/17

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F / J.L 07/04/17

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/24
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:34:26 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 31792

Part Number: D28582

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Sn 07/04/17 (27)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Deburr any rough edges after tumbling

J.F. 07/04/17 (27)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sn 07/04/17 (27)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

M-L

07/04/18 (27X)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

M103706

27

04-04-23 (27)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/04/24 (27)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/04/24 (27)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/24

Job Completion



u 07.04.24

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|-----------------------------------|---------------|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 31792 |
| Description: Hinge Bracket | | Part Number: D2858-2 |
| Inspection Dwg: D2858 | Rev: B | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.171 | +0.005/-0.000 | .175 | ✓ | | | |
| Ø0.400 | +0.005/-0.000 | .400 | ✓ | | | |
| R0.125 | +/-0.010 | .125 | ✓ | | | |
| 0.328 | +/-0.010 | .328 | ✓ | | | |
| 0.820 | +/-0.005 | .820 | ✓ | | | |
| 1.476 | +/-0.010 | 1.477 | ✓ | | | |
| 0.342 | +/-0.010 | .342 | ✓ | | | |
| 0.875 | +/-0.010 | .874 | ✓ | | | |
| 1.56 | +/-0.030 | 1.562 | ✓ | | | |
| 0.147 | +/-0.010 | .150 | ✓ | | | |
| 0.717 | +/-0.010 | .721 | ✓ | | | |
| 0.697 | +/-0.010 | .698 | ✓ | | | |
| 0.229 | +/-0.010 | .230 | ✓ | | | |
| R0.125 | +/-0.010 | .125 | ✓ | | | |
| R0.063 | +/-0.010 | .063 | ✓ | | | |
| 0.063 | +/-0.010 | .065 | ✓ | | | |
| 0.126 | +/-0.010 | .127 | ✓ | | | |
| 0.630 | +/-0.010 | .629 | ✓ | | | |
| R0.354 | +/-0.010 | .354 | ✓ | | | |
| 0.965 | +/-0.010 | .966 | ✓ | | | |
| Ø0.166 | +0.005/-0.000 | .168 | ✓ | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

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|--------------------------|-------------------------|--------------------------------|
| Measured by: J.L. | Audited by: B.G. | Prototype Approval: N/A |
| Date: 07/04/16 | Date: 07.04.16 | Date: N/A |

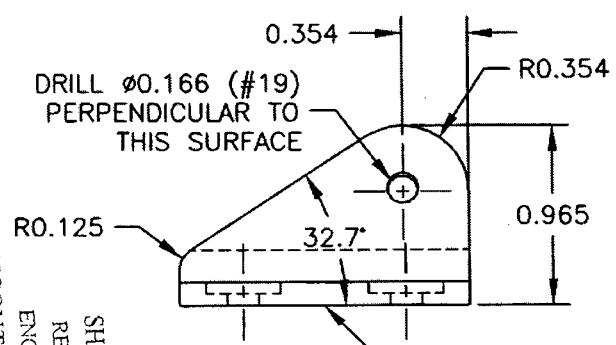
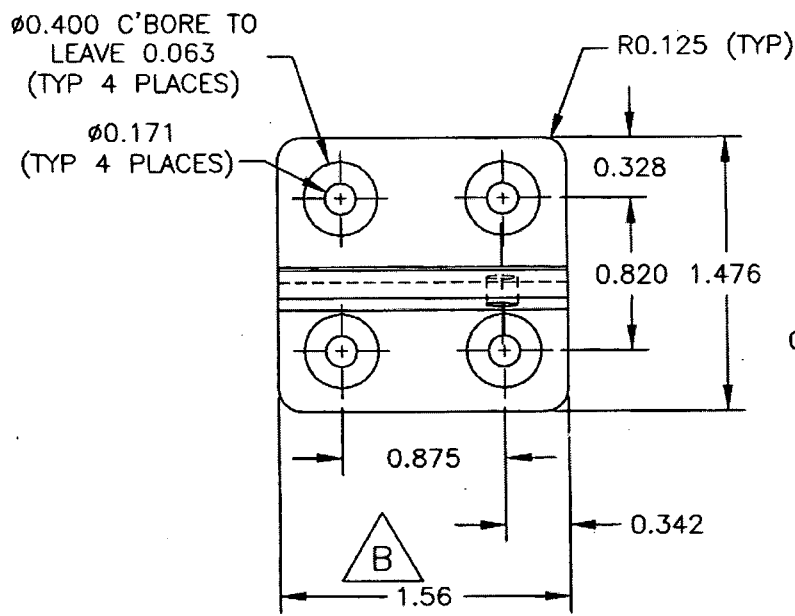
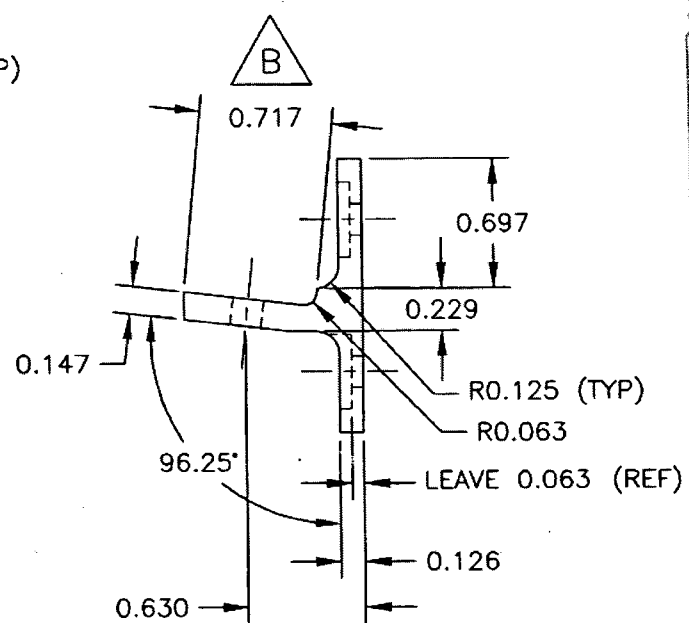
| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 04.11.11 | New Issue | KJ/JLM | Shiff |

DART



RELEASED
99.01.03 KE

| DESIGN | | DRAWN BY | | DART AEROSPACE LTD | |
|----------|--|---------------|--|---------------------------------|--|
| CHECKED | | APPROVED | | DRAWING NO. | |
| DATE | | TITLE | | SHEET 1 OF 1 | |
| 99.02.28 | | HINGE BRACKET | | SCALE | |
| A | | 98.12.14 | | NEW ISSUE | |
| B | | 99.02.28 | | 0.717 WAS 0.667, 1.56 WAS 1.559 | |



ENGRAVE P/N CENTERED ON
BASE 0.003 DEEP (0.010 MAX)

D2858-1 SHOWN
D2858-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO. 21142

WORK ORDER
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE